



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D2920-2

Job Sheet 202873



Part No: D2920-2

Job Qty: 4 pcs

Part Name: Inner Saddle (Aft RH)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/5/19

Job Tracking No:

Due Date: 12/23/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D2920 REV.B IPP Rev. A 19.10.28 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Machining - Issue SN	43 pcs	12/23/19	12/23/19	0.00	0.00	HAAS - 1		
							HAAS - 2		
							HAAS - 3		SBL 20/01/05
							HAAS - 4		
100	HAAS 4 Axis	43 pcs	12/23/19	12/23/19	2.00	7.50	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		SBL 20/01/06
							HAAS - 4 - B4B		
110	Conventional Mill - 1 - B4B	43 pcs	12/23/19	12/23/19	0.00	0.53	Conventional Mill - 1 - B4B		SBL 20/01/06
							Conventional Mill - 2 - B4B		
120	QC 2	43 pcs	12/23/19	12/23/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		



Container No: S244757



Part: D2920-2

Job No: 202873

Serial No/Batch: S244757

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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Date: 01/05/20

Plex 11/5/19 8:00 AM Dart.lajeunesse.marie

				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	SBL 2010/10/6
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130 QC 8	* 3 pcs	12/23/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	A.p 20-04-28
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Handfinish - 1-1 Chemical-B4B	* 3 pcs	12/23/19	0.00 0.19	Handfinish - 1 - 1 - B4B	3EB20-04-30
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Plex 11/5/19 8:00 AM Dart.lajeunesse.mari	

					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
145 QC 3	★ 3 pcs	12/23/19	0.00 0.00		QC 3 - 10	
QC 3 DAS 47 9-89 OCT 27 2020 M25469.					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
150 Powdercoat - 1 White GI(A)- B4B	★ 3 pcs	12/23/19	0.00 0.17		Powdercoat - 1 - B4B	
START: 7:20 O.V. 7:30 Finish 7:50					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
160 QC 3	★ 3 pcs	12/23/19	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	

				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
170	Packaging 3-1 - Stock - B4B	* 3 pcs	12/23/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
180	QC 21 - SA	* 3 pcs	12/23/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 100 - (HAAS CNC Vertical Machine) Program batch number Machine Step No 1 as per Folio FC AA and visually inspect
 Descriptions: as per Dwg D2920 & attached Dimension Sheet Machine Step No 2 as per Folio FC AA and visually inspect as per Dwg
 D2920 & attached Dimension Sheet Machine Step No 3 as per Folio

110 - (Manufacture as per dwg) Machine Keyway and inspect per Dwg D2920 & attached dimension sheet

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

145 - (QC3- Inspect Part Finish)

150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____

160 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg & Stock Location: _____)

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6102-010	Saddle Billet	* 3 pcs (1 ea)	90-Machining - Issue SN	S23C 580

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Machining - Issue SN	D6102-010	* 3	0	0

Part Specifications

Specifications could not be found.

Plex 11/5/19 8:00 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 202 873
Description: Inner Saddle		Part Number: D29202
Inspection Dwg: D2920 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	1.240	1.260		1.250	1.252	1.252		
B	Ø0.437	Ø0.443		.438	.438	.438		
C	0.490	0.510		.500	.494	.501		
D	1.745	1.755		1.750	1.750	1.750		
E	3.495	3.505		3.500	3.500	3.500		
F	1.745	1.755		1.750	1.750	1.750		
G	7.990	8.010		7.998	7.996	8.002		
H	0.514	0.534		.525	.523	.525		
I	0.090 x 45°	0.110 x 45°		.097 x 45°	.110 x 45°	.098		
J	1.510	1.525		1.520	1.520	1.520		
K	0.175	0.205		.190	.191	.191		
L	R0.178	R0.198		.188	.188	.188		
M	0.225	0.255		.240	.242	.240		
N	R0.490	R0.510		.500	.500	.500		
O	0.740	0.760		.753	.753	.753		
P	3.495	3.535		3.520	3.520	3.520		
Q	0.315	0.335		.325	.325	.323		
R	0.180	0.220		.215	.210	.213		
S	1.762	1.782		1.780	1.780	1.780		
T	0.250	0.270		.260	.261	.261		
U	4.436	4.446		4.441	4.441	4.441		
V	1.498	1.508		1.503	1.503	1.503		
W	1.498	1.508		1.503	1.503	1.503		
X	0.713	0.733		.731	.726	.727		
Y	1.278	1.288		1.283	1.283	1.283		
Z	1.103	1.113		1.110	1.108	1.108		
AA	1.225	1.235		1.230	1.230	1.230		
AB	1.225	1.235		1.230	1.230	1.230		
AC	Ø0.256	Ø0.262		.258	.258	.258		
AD	R0.490	R0.510		.500	.500	.500		
AE	0.225	0.255		.240	.240	.240		
AF	0.760	0.765		.760	.760	.760		
AG	0.308	0.312		.310	.311	.311		
AH	2.050	2.055		2.050	2.050	2.050		
AI	0.615	0.635		.624	.625	.625		
AJ	1.240	1.260		1.250	1.252	1.252		
AK	0.352	0.372		.365	.365	.365		
Accept/Reject								

Measured by: SBL	Date: 20/01/06
Audited by: B.e	Date: 20-04-28
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	05.09.19	New Issue	KJ/JLM	
B	08.04.21	Reformat	KJ/JLM	